

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 14.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014496**Date Inspected:** 25-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** C. K. Johnson Industries, Arcata, Ca.**Location:** San Leandro, CA**CWI Name:** Seth Ronald**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at Testing Engineers in Sam Leandro, CA as requested. This QA Inspector was on site to randomly review the Radiographic Testing (RT) performed for the radiography of various Procedure Qualification Record (PQR) test plates. This QA Inspector met with Quality Control (QC) Inspector Seth Ronald and was informed the radiographic film had been read and that each of the (4) PQR test plates were accepted.

This QA Inspector performed a random verification of the radiographic film for each of the following test plates:

- 1) 1-1-M-FC-1G-1 (Maximum Heat Input)
- 2) 1-1-M-FC-1G-2 (Minimum Heat Input)
- 3) 1-1-M-FC-3G-1 (Maximum Heat Input)
- 4) 1-1-M-FC-3G-2 (Minimum Heat Input)

The radiographic film appeared to meet the contract requirements for both film quality and weld quality. This QA Inspector review the radiographic shooting parameters, such as but not limited to; Source to Film Distance (SFD), geometric un-sharpness, film selection, film developing technique and Image Quality Indicator (IQI) selection.

In general the work observed appeared to comply with the contract requirements, please see Welding Witness Report (TL-6032) this date for further details.

Summary of Conversations:

As noted above.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
